

Split

Work Order ID 70592-2

Wednesday, July 06, 2011 8:37:36 AM



Page 1

Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

190

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

5/10/12

for BG 11-8-12
②

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 4109929

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: 4114596

EP 11/08/11 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70592

Wednesday, July 06, 2011 8:37:36 AM



Page 2

Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



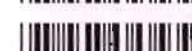
Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

Swloslw1

22

QC

Memo

0.00

44

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

11/8/12/20

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

Swloslw2

42

QC

Memo

0.00

44

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 70592

Wednesday, July 06, 2011 8:37:36 AM



Page 3

Item ID: D412-630-033

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev: A

160

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/8/16 22

11/8/16 16

11-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector,

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 8:37:32 AM

Page 1

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding



Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-107



Clevis

Manufactured

No

110

Each

15.0000

1

3

Location

Loc Qty

Loc Code

WA005

15

66811

15

D2803-041



Bracket Assembly

Manufactured

No

110

Each

4.0000

1

3

Location

Loc Qty

Loc Code

ST149

4

61724

2

71006

2

D2804-041



Bracket Assembly

Manufactured

No

110

Each

1.0000

1

3

Location

Loc Qty

Loc Code

ST150

1

61726

1

SP11/07/01

3
SP11/07/01

1
2
SP11/07/01

1
B 70998 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 2

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2837-041

Manufactured No

110

Each

25.0000

2

6



Door prop



EP 11/07/21

Location

Loc Qty

Loc Code

ST022

17

60540

2

69671

15

ST023

8

68494

8

3
3

D2813

Manufactured No

110

Each

21.0000

2

6



Washer



EP 11/07/21

Location

Loc Qty

Loc Code

ST023

21

69386

21

6

D3562-041

Manufactured No

110

Each

1.0000

1

3



Step Assembly, LH



EP 11/07/21
371382 (3x)

Location

Loc Qty

Loc Code

FG110

1

54963

1

D3395-1

Manufactured No

110

Each

60.0000

4

12



Bushing



EP 11/07/21

Location

Loc Qty

Loc Code

ST052

60

69387

20

70775

40

8
4

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN3C21A
BOLT

Purchased

No

110 Each

77.0000 2



6
LB 11/07/21

Location

Loc Qty

Loc Code

ST352

77

109148

7

117366

20

117514

50

5

AN8C16
Belt

Purchased

No

110 Each

37.0000 2



6
LB 11/07/21

Location

Loc Qty

Loc Code

ST345

37

106066

37

6

AN310C8
Nut

Purchased

No

110 Each

33.0000 2



6
LB 11/07/21

Location

Loc Qty

Loc Code

ST324

33

117771

23

118091

10

6

MS24665-302
Cotter Pin

Purchased

No

110 Each

184.0000 6



18
LB 11/07/21

Location

Loc Qty

Loc Code

ST357

184

117460

184

18

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 4

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H3

Purchased

No

110

Each

166.0000

4

12



Washer



EP 11/07/21

Location

Loc Qty

Loc Code

ST277

166

116373

6

117460

60

118078

100

NAS1515H5L

Purchased

No

110

Each

68.0000

4

12



WASHER



EP 11/07/21

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

28

111359

28

NAS1515H8

Purchased

No

110

Each

227.0000

4

12



Washer



EP 11/07/21

Location

Loc Qty

Loc Code

ST278

227

111275

35

111411

192

12

1118378 (12)

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-3 Purchased

No

110

Each

1,133.000

4

12



Nut



EP 11/07/21

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1061

112314

69

118077

992

39

MS24693-C280 Purchased

No

110

Each

41.0000

2

6



Screw



EP 11/07/21

Location

Loc Qty

Loc Code

ST310

40

115594

10

118093

30

ST318

1

111279

1

42

D2806-1 Manufactured

No

130

Each

26.0000

2

6



Bushing



sl 11/8/12 (2)

Location

Loc Qty

Loc Code

ST022

26

68492

6

70885

20

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Wednesday, July 06, 2011 8:37:33 AM

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

D2806-3

Manufactured No

130

Each

27.0000

2



Bushing

Location

Loc Qty

Loc Code

ST022

27

69401

7

70886

20

D2810-5

Manufactured No

130

Each

8.0000

1



Strut

Location

Loc Qty

Loc Code

ST265

8

52034

1

69402

7

D3396-1

Manufactured No

130

Each

38.0000

2



Spacer

Location

Loc Qty

Loc Code

ST052

38

46748

8

69906

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Wednesday, July 06, 2011 8:37:33 AM

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

130

Each

410.0000

1

3



Bolt

Location

Loc Qty

Loc Code

EG	4	
103344	4	
ST306	12	
117313	12	
ST356	394	
116704	19	
117619	150	
117794	50	
117872	75	
118191	100	

AN4C10A

Purchased

No

130

Each

73.0000

1



Belt

Location

Loc Qty

Loc Code

ST356	73	
112243	43	
114523	30	

AN5C15A

Purchased

No

130

Each

65.0000

2



Bolt

Location

Loc Qty

Loc Code

ST338	20	
118191	20	
ST339	45	
111819	7	
117764	13	
117885	25	

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 8:37:34 AM

Page 8

Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

AN44C7A

Purchased

No

130

Each

65.0000



Eyebolt



1

3

Location

Loc Qty

Loc Code

ST362

65

109013

25

111308

40

Purchased

No

130

Each

93.0000

AN4C15A



Bolt



2

6

Location

Loc Qty

Loc Code

ST358

93

115835

11

117441

32

117795

50

Purchased

No

130

Each

180.0000

NAS1515H4



Washer



7

21

Location

Loc Qty

Loc Code

ST277

180

111525

2

116169

3

117460

50

117735

75

118078

50

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Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 8:37:34 AM

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Work Order ID: 70592

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 6/10/2011

Required Date: 7/11/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1515H5

Purchased

No

130

Each

167.0000

7

21

134

M118384



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

127

103286

100

109430

27

MS21043-4

Purchased

No

130

Each

897.0000

4

12

12

M118388



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

857

117601

357

117793

500

MS21043-5

Purchased

No

130

Each

583.0000

3

9

12

11/8/12sl (2)



Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

463

112314

363

116548

100

ST314

100

118159

100

Wednesday, July 06, 2011 8:37:34 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

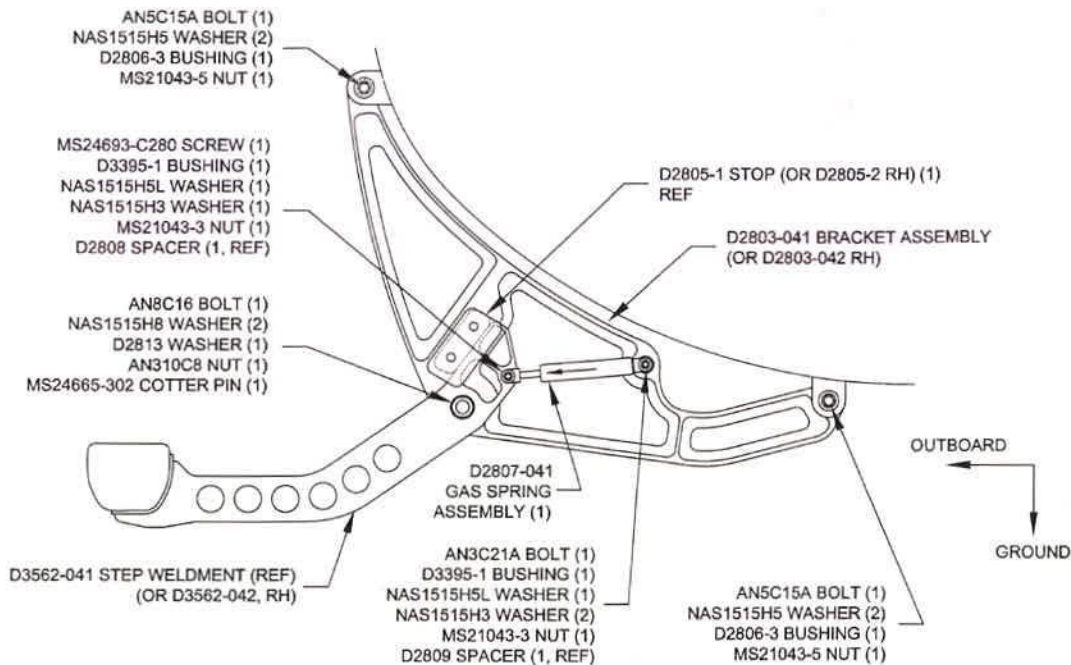
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

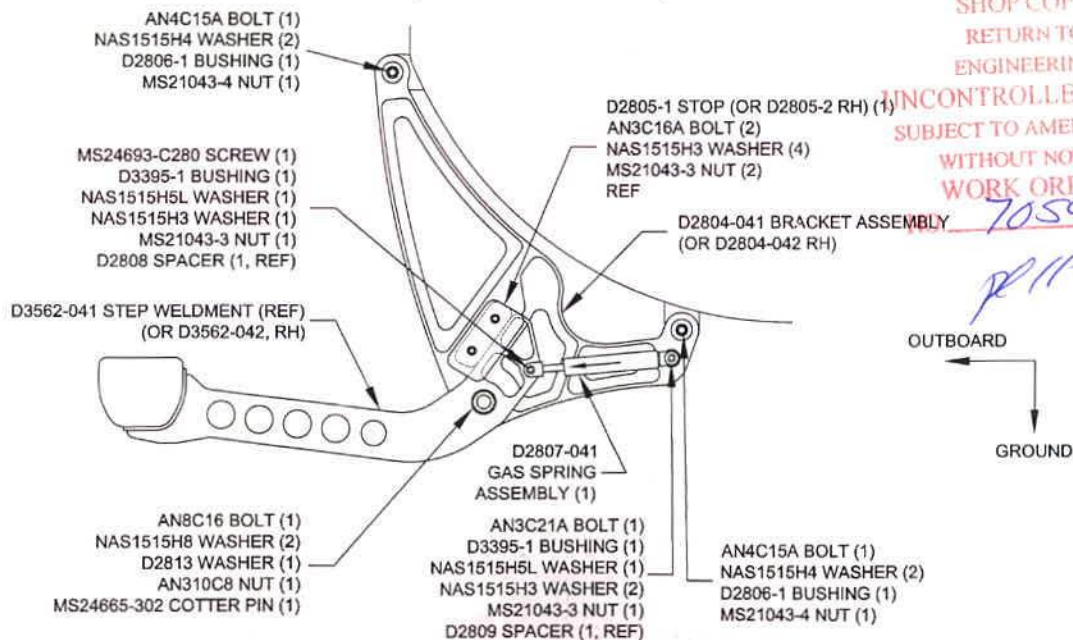
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation



**FIGURE 25-13: STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
70592
P/H-06-13

**FIGURE 25-14: STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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25-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

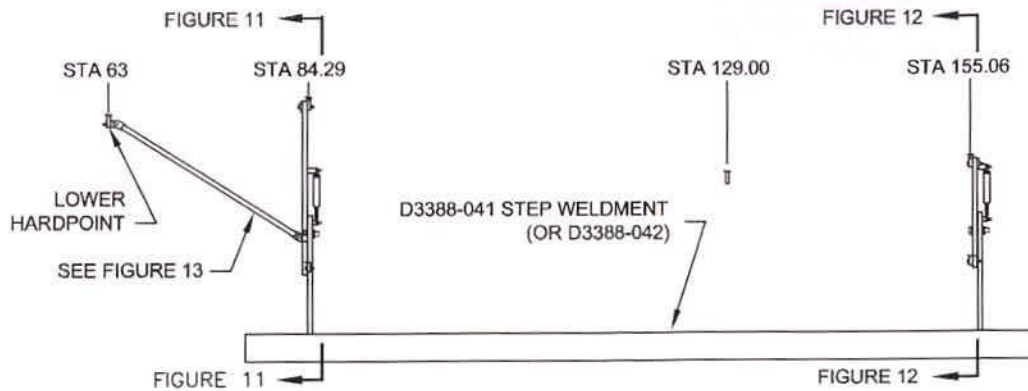
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

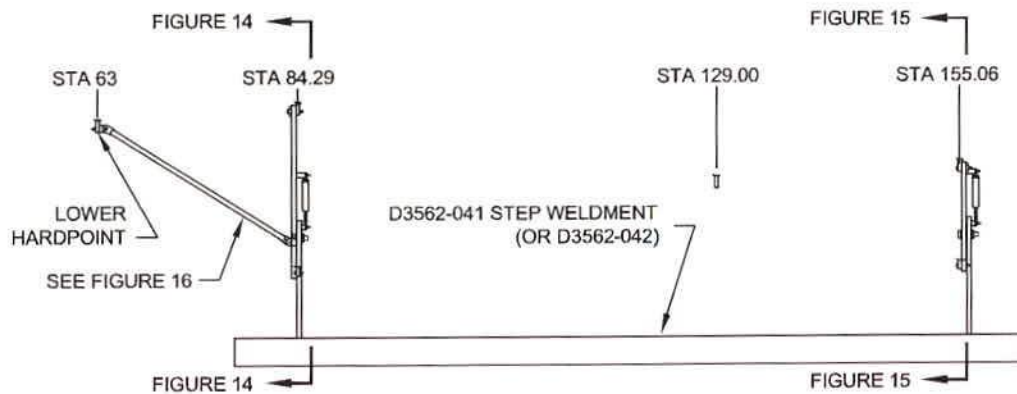
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

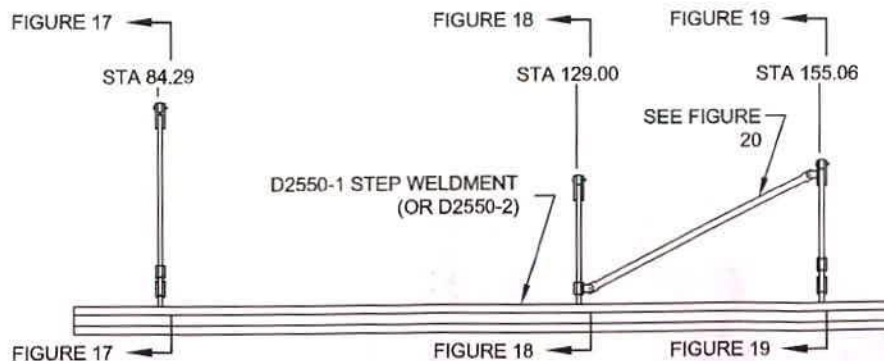


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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